

Date: Wednesday, 5/10/2006 1:34:20 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BEARING CAP
Job Number :	27055		
Estimate Number :	12412		
P.O. Number :	N/A	Part Number :	D312125
This Issue :	5/10/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3121 REV C2
First Issue :	N/A	Project Number :	N/A
Previous Run :	N/A	Drawing Revision :	C2
	Type :	Material :	N/A
	MACHINED PARTS	Due Date :	5/17/2006
Written By :	<u>SEE COMMENT BELOW</u>		Qty: 300 Um: Each
Checked & Approved By :	<u>SEE ABOVE USER & DATE</u>		
Comment :	Est Rev:A New Issue 06-05-10 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELINR12500	DELIN ROUND BAR 1.25"
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Comment: Qty.: 0.0546 f(s)/Unit Total : 16.3800 f(s)

Material: Ø1.25 Delrin Rod ← Ø1.000 M8

(M-DELIN-R1.2500) Identify as D3121-25

Batch: M100612 / M16128 / M100010

1.375 Batch M100010 06/05/11

M8 06/05/10

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn D3121-25 Cap as per Folio FA387

2-Deburr

1.00

M8 06/05/15 287

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M8 06/05/15 287

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

06/05/11 287

5.0	D312123	Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 300.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D3121-23	Bearing	
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N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/05/15

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/10/2006 1:34:20 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING CAP

Job Number: 27055

Part Number: D312125

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *AAA*

W 06-05-15

287

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/05/15

Job Completion



W 06-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

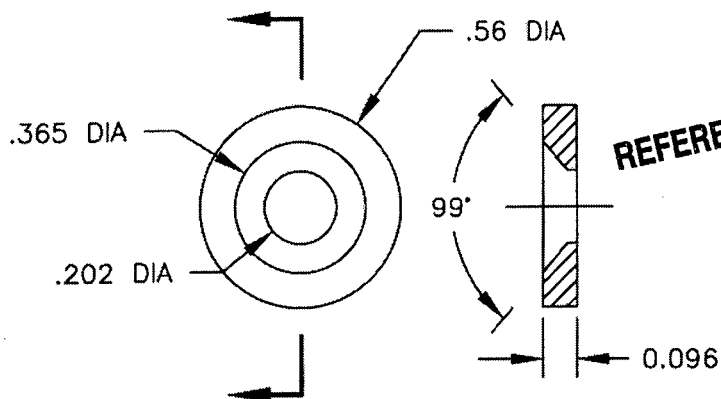
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

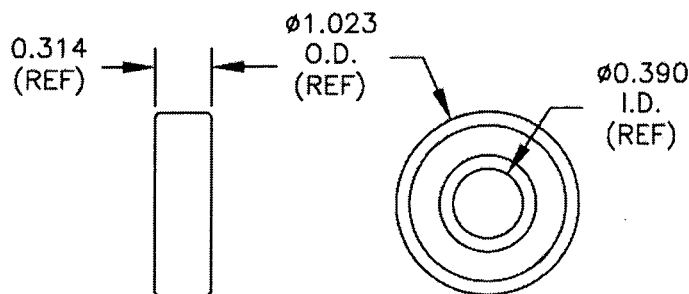


DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 10 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



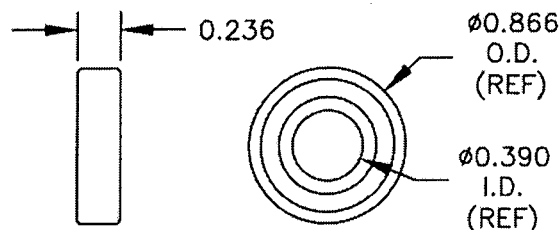
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-19 BEARING (SCALE 1:1)

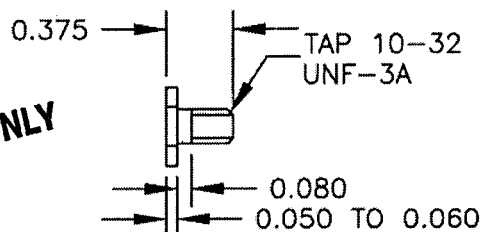
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



D3121-23 BEARING (SCALE 1:1)

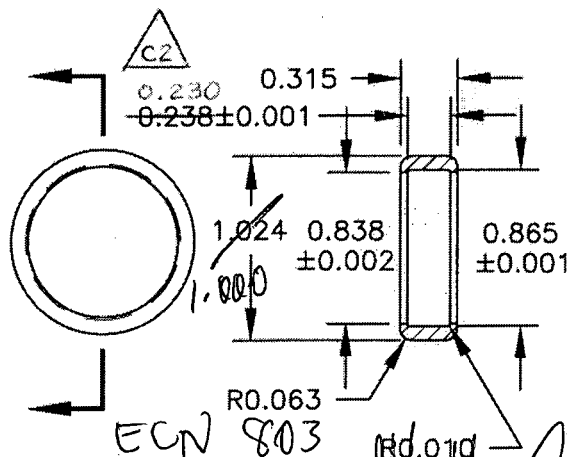
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

REFERENCE ONLY



D3121-21 BOLT (SCALE 1:1)

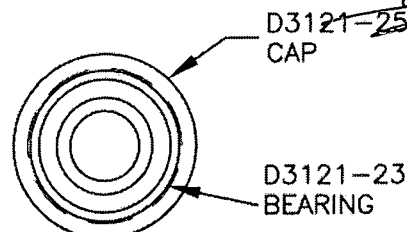
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, 1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

RELEASED
04.03.01



D3121-241 BEARING ASSEMBLY (SCALE 1:1)

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Linda Lacelle

From: Bill Beckett [bbeckett@dartaero.com]
Sent: Wednesday, May 10, 2006 1:19 PM
To: 'Linda Lacelle'
Cc: Serge Shahbazian (E-mail); Jason Loader (E-mail); Jean-Luc Menard (E-mail); Peggy McDonald (E-mail); Dale Trepanier (E-mail)
Subject: RE: 1" caps

Linda,
As discussed, please launch a WO immediately to make 400 of these caps D3121-25 at 1.000" OD rather than the 1.024" indicated on the drawing. Serge will give you a marked up print shortly to cover this. We will be changing this part for all future production as well, including items in-stock.
Jason will give us a ship to address shortly. DND has been directed to install all their cabin door roller kits by the end of May, so we need to get these out to them ASAP.

Thanks,
Bill

PS: Jason - could you please sort out the details of the "no-charge" PO with Peggy to cover these new caps. By the way, we will include an instruction as to how to replace the caps on the brackets.

PPS: Dale - please ensure Peggy has the appropriate PAR or CSR.

-----Original Message-----

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: May 10, 2006 12:39 PM
To: Bill Beckett (E-mail)
Subject: 1" caps

The drwg has not been changed.... If someone could get this changed to 1", I can get someone started on them asap.
LL